

Date: Thursday, 04/12/2008 10:34:03 AM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 05065
Estimate Number : 13639
P.O. Number :
This Issue : 04/12/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL /MED FAB
Previous Run : 43913

Drawing Name : ANGLE

Part Number : D37091

Drawing Number : D3709 PRELIM

Project Number : N/A

Drawing Revision : PRELIM

Material :

Due Date : 11/12/2008

Qty: 3 Um: Each

Written By :
Checked & Approved By : MF 08-12-04

Comment : Est Rev:A 08-10-31 new issue DD verified by:EC

Additional Product

Job Number:



PRELIMINARY ISSUE
04.01-16 per ECN # 04.502P

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.2855 sf(s)/Unit Total: 0.8565 sf(s)

6061T6 aluminium sheet .063" thick

(M6061T6S063)

Batch: 108279 1B 8-12-5

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3709

Dwg Rev: PRE 1B 8-12-5

Prog Rev: Lim

****grain direction on a 45 degree ****

2- Deburr if necessary 1B 8-12-5

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Form as per dwg D3709

06.12.05 09/01/13

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/12/2008 10:34:03 AM
User: Melodie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 05065

Part Number: D37091

~~PROTOTYPE~~

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

3

09/01/15

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

09/01/15

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/01/15

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

38

9/6/8

50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/08

Job Completion



MF 09-01-16

POSITIVE RECALL
EFFECTIVE 09.01.12 AUTH
RELEASE DATE 09.06.05

8 7 6 5 4 3 2 1

D

C

B

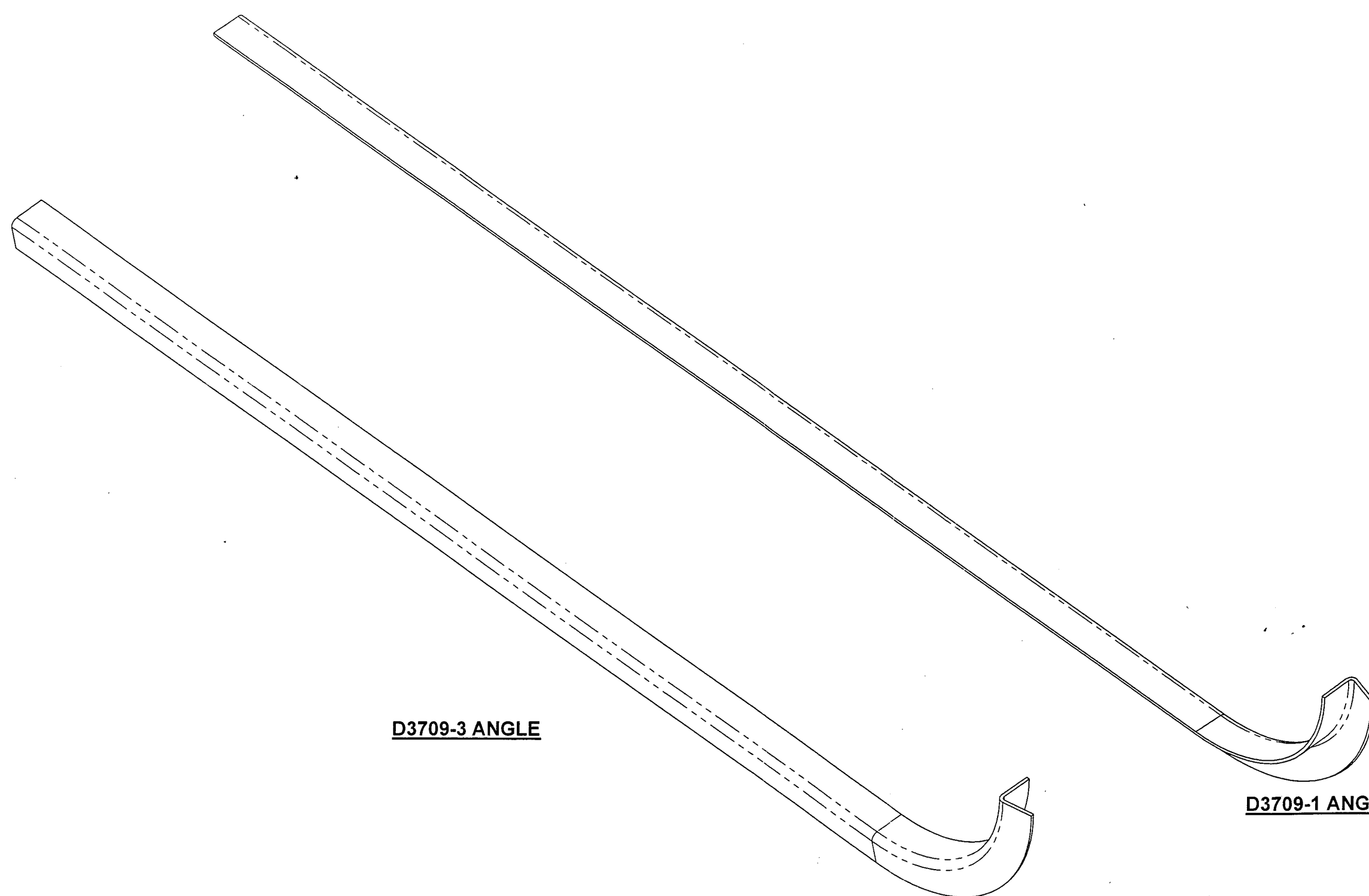
A

D

C

B

A

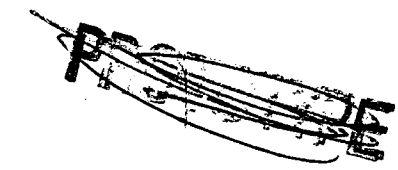


D3709-3 ANGLE

D3709-1 ANGLE

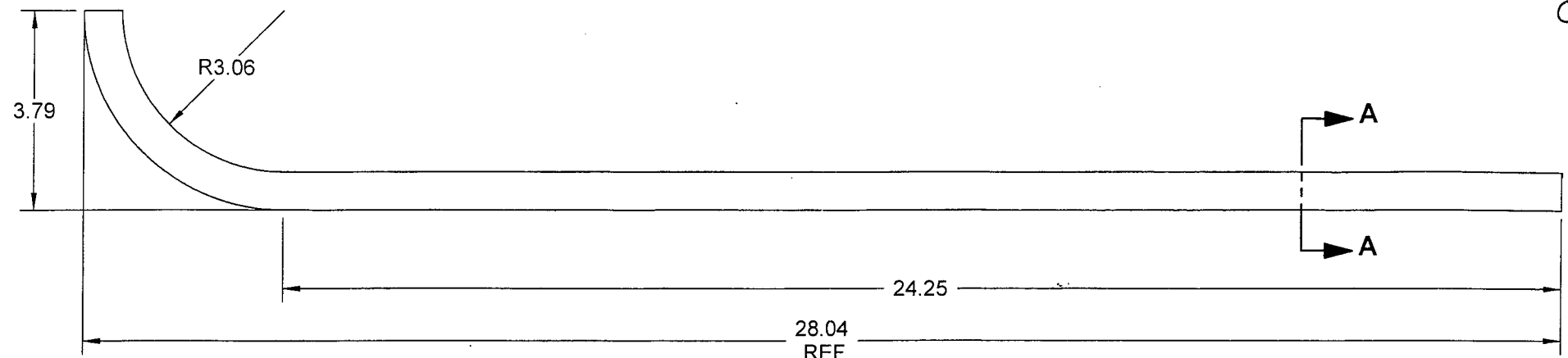
**PRELIMINARY
ISSUE**

08/10/31 MP

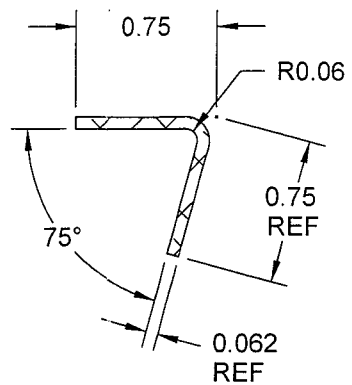


- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3709-1 = 0.24 lbs
D3709-3 = 0.16 lbs

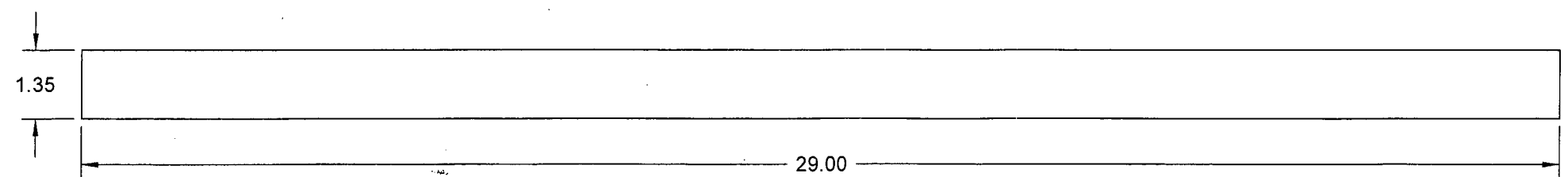
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REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3709	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
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D3709-1 ANGLE
(MAKE FROM D3709-1F)



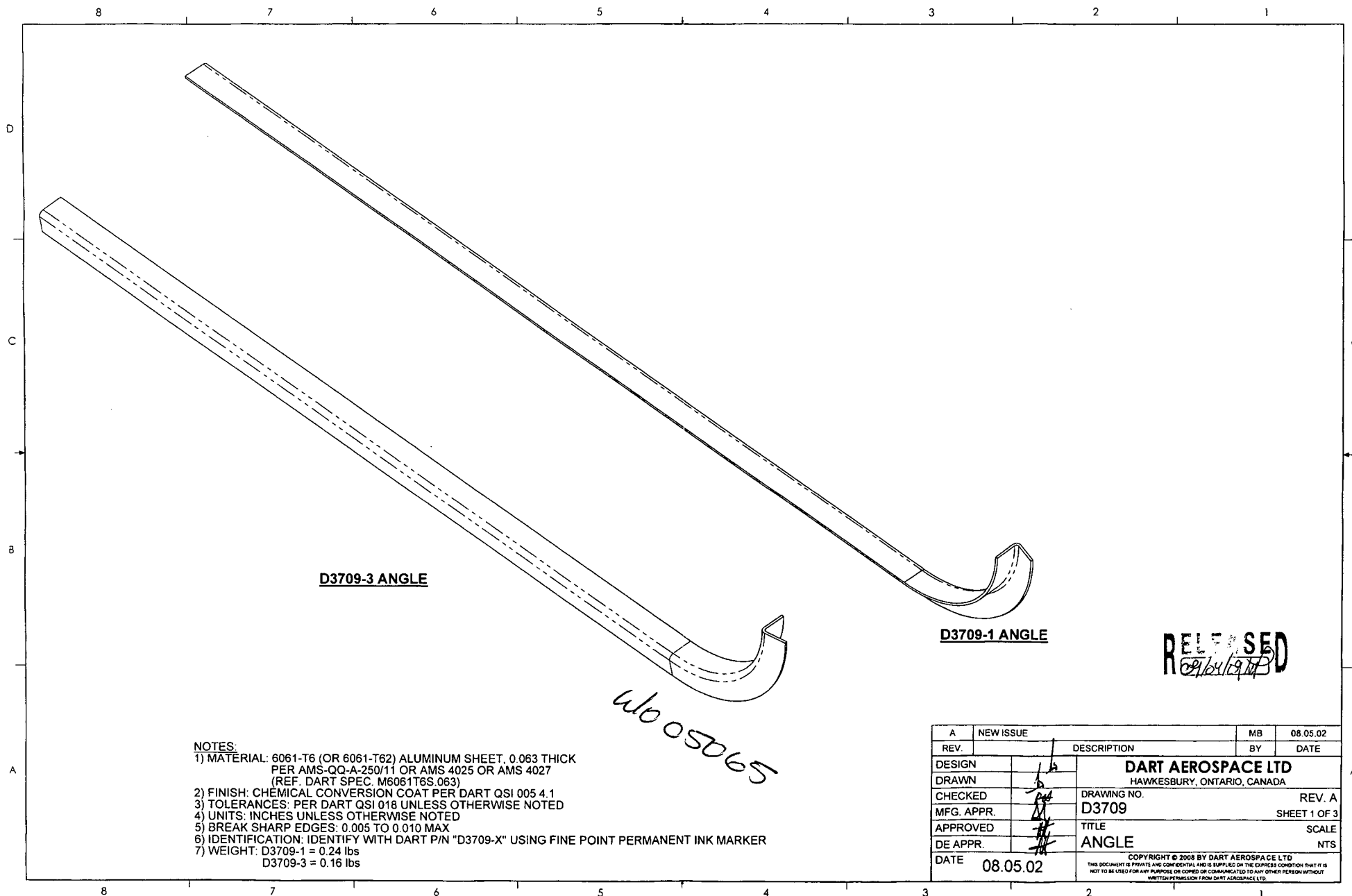
SECTION A-A
SCALE 2X



D3709-1F ANGLE FLAT PATTERN

PROTOTYPE

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MFG. APPR.		D3709	SHEET 2 OF 3
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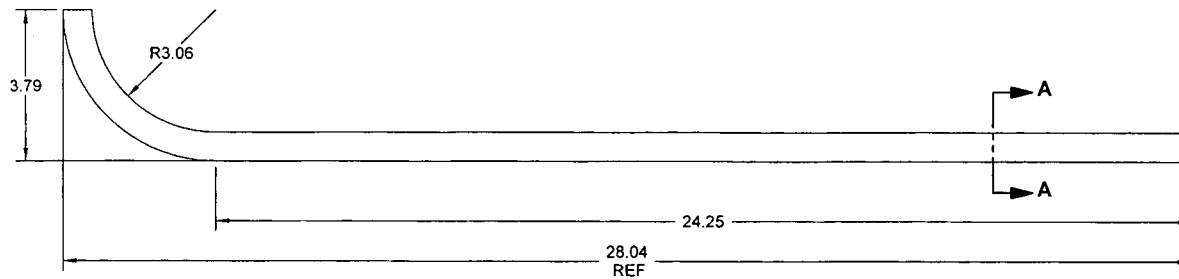
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DE APPR.			
DATE	08.05.02		

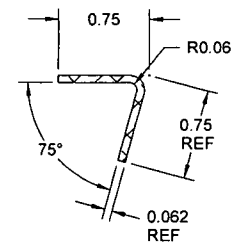
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DRAWING NO. **D3709** REV. A
TITLE **ANGLE** SCALE NTS

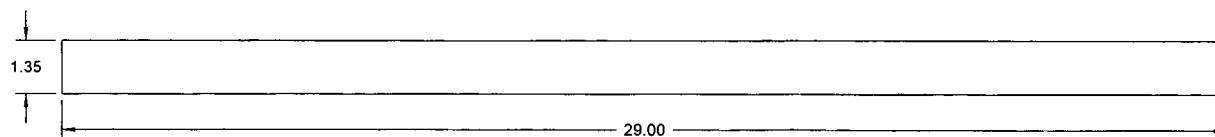
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D3709-1F ANGLE
(MAKE FROM D3709-1F)



SECTION A-A
SCALE 2X



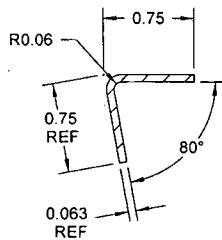
D3709-1F ANGLE FLAT PATTERN



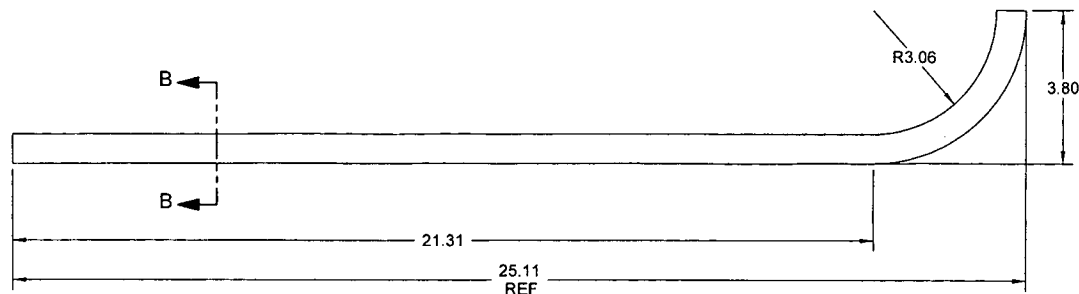
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09/04/09

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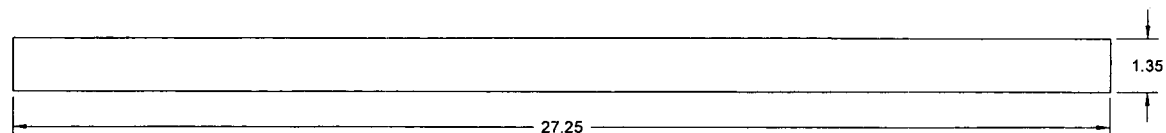


SECTION B-B
SCALE 2X



D3709-3 ANGLE
(MAKE FROM D3709-3F)

GRAIN
DIRECTION



D3709-3F ANGLE FLAT PATTERN

RELEASED
07/04/09

W6
05065

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MFG. APPR.	<i>[Signature]</i>	D3709	SHEET 3 OF 3
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